

Work Order ID 142583

Thursday, March 10, 2016 10:50:42 AM

142583

Page 1

Item ID: D3950-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rivet **500** **MAR 11 2016**
 Start Date: 3/14/2016 Start Qty: ~~50.00~~ ***50*** **DAS**
 Required Date: 3/23/2016 Req'd Qty: ~~50.00~~ ***50*** **13**
 Reference: **9-89** Cust Item ID: Customer:

Approvals: Process Plan: MLJ Date: MAR 10 2016 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3950	REV A

100 0.00
100 **500** **MAR 16 2016** **DAS**
 Purchasing Memo 0.00 **13**
 Purchasing Issue P/O: 31715 **9-89**
 Purchase Part Number: PR-71
 Supplier: SPAENAU
 Certificate of conformity is required

110 Receive & Inspect for Damage & Mat'l Certs 0.00
110 **500** **8/6-03-24**
 Packaging Memo 0.00
 Packaging Ensure material certification is attached **SP 500 16-03-24**

120 QC6- Inspect dimensions to drawing 0.00
120 **500**
 QC Memo 0.00 **DAS**
 Quality Control **38**
9-89
MAR 24 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Thursday, March 10, 2016 10:50:42 AM

Page 2

20160328

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Picklist Print

Thursday, March 10, 2016 10:50:48 AM

Page 1

Work Order ID: 142583

142583

Parent Item: D3950-1

D3950-1

Parent Item Name: Rivet

Start Date: 3/14/2016

Required Date: 3/23/2016

Start Qty: 50.00

Required Qty: 50.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PR-71 *PR-71* Rivet		Purchased			No		Each	0.0000		50			
										**	500x 8p/6 ez 24		

DQA: _____ Date: _____



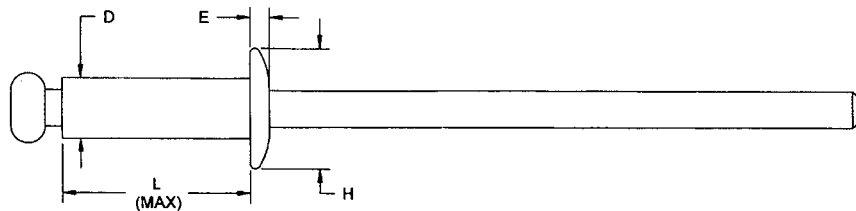
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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				Completed By	
				Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

SPECIFICATION CONTROL DRAWING



D3950-X RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 142583 MJS
16-03-10

DART PART NUMBER	DESCRIPTION	SUPPLIER	SUPPLIER PART NUMBER	MANUFACTURER NUMBER	RIVET BODY DIAMETER "D"	HOLE SIZE AND DRILL NUMBER	GRIP RANGE	LENGTH UNDER HEAD "L"	HEAD DIAMETER "H"	HEAD HEIGHT "E"
D3950-1	RIVET - 5056 ALUMINUM BODY WITH COATED CARBON STEEL MANDREL	SPAENAUER	PR-71	AD44BS	0.125	0.129 - 0.133 #30	0.188 - 0.250	0.390	0.250	0.040

RELEASED
2009-08-28
MJS

- NOTES:
- 1) MATERIAL: SEE TABLE
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A

A	NEW ISSUE	09.06.05
REV.	DESCRIPTION	BY DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.06.05	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3950	REV. A SHEET 1 OF 1
TITLE RIVET	SCALE NTS
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31715

Purchase Order Date 3/16/2016

PO Print Date 3/16/2016

Page Number 1 of 6

Order From :

HASKINS INDUSTRIAL
5-52 ANTARES DRIVE
NEPEAN, ON K2E 7Z1
CA

VC-HAS001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name
Vendor Phone 613 723 8800

Ship To Contact
Ship To Phone
Ship Via: Dicom
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

MAR 18 2016

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3672-3P AS PER DWG D3672 REV. C B142571	Washer	3/22/2016 Yes 3/22/2016		500.00 Each	\$0.34	\$170.65
Line Total:							\$170.65
2	D3672-7P AS PER DWG D3672 REV. C B142572	Washer	3/22/2016 Yes 3/22/2016		500.00 Each	\$0.34	\$170.65
Line Total:							\$170.65
3	PR-71 AS PER DWG D3950 REV. A B142583	Rivet	3/22/2016 Yes 3/22/2016		500.00 Each	\$0.03	\$14.70

Note:

3/16/2016

HASKINS INDUSTRIAL INC.
5-52 ANTARES DRIVE

*** B A C K O R D E R ***

Order # 1260914.02

NEPEAN, ONTARIO K2E 7Z1
TEL (613) 723-8800 FAX (613) 723-8806

Order Date 03/16/16

Page 1 of 1

Sold To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY
ON
K6A 1K7

Ship To: DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY
ON
K6A 1K7

* Reprint *

Cust Phone #	Warehouse	F.O.B.	Taken By
	NORTH BAY	DEST	Sylvie 613-723-8800

Cust #	Customer P/O #	Required	Orig Order	Slsm	Ship Via	Terms
05168	31715	03/17/16	1260914.02	PL	DTCOM	NET 30

Ln#	Bin #	Order UM	Ship	B/O Product	Description
-----	-------	----------	------	-------------	-------------

14
PRICED BY THE BOX

1 EA

1

SPIXI

PR-71 RIVET BOX

OF 500 PIECES

Spk 03-24

PLEASE NOTE:

1. NO RETURNS WITHOUT PRIOR AUTHORIZATION
 2. ALL SHORTAGE CLAIMS MUST BE WITHIN 10 DAYS
 3. BO CODE: BO = QTY NOT SHIPPED IS BACK-ORDERED
- CL- QTY NOT SHIPPED WAS CANCELLED
SC- ITEM CONSIDERED COMPLETE - NO B/O CREATED

FILL *JA* PACK DATE 03/21/16
Printed on 2016-03-21 at 10:03